

Date: Monday, 5/1/2006 4:22:42 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTLET WELDMENT (206)
Job Number	: 26906		
Estimate Number	: 10473		
P.O. Number	: N/A	Part Number	: D2414
This Issue	: 5/1/2006	Drawing Number	: D2414 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 6/30/2006
Checked & Approved By	: <u>06.05.02</u>	Qty:	<u>3</u> Um: Each
Comment	: Est: C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2292	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Heater Tube 4"

Qty	Part Number	Description
1	D2292	4" Ring

Batch

B21844 ③

06/05/16 ②

2.0	D2406	3" Heater Tube
-----	-------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

3" Heater Tube

Qty	Part Number	Description
1	D2406	3" Tubing

Batch

B17130 ①

B26914 ②

06/05/16 ②

3.0	D2415	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

End Plate

Qty	Part Number	Description
1	D2415	End Plate

Batch

B24358

06/05/16 ②

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D2414 Outlet Assembly as per Dwg D2414 and QSI 004.

06/05/16 ②

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 4:22:42 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT (206)

Job Number: 26906

Part Number: D2414

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 06.05.16

(3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DL 06.05.23

(3)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

PPP ~~8A~~

06/5/24 (3)

8.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 1342

Red Anodize D2414 as per Dwg D2414

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

CL 06.05.26 (3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

06/6/5 (3)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-06 (3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 171

06/6/6 (3)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/07

06.06.07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2414	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 OUTLET WELDMENT	SCALE

RELEASED
96/09/10 BW

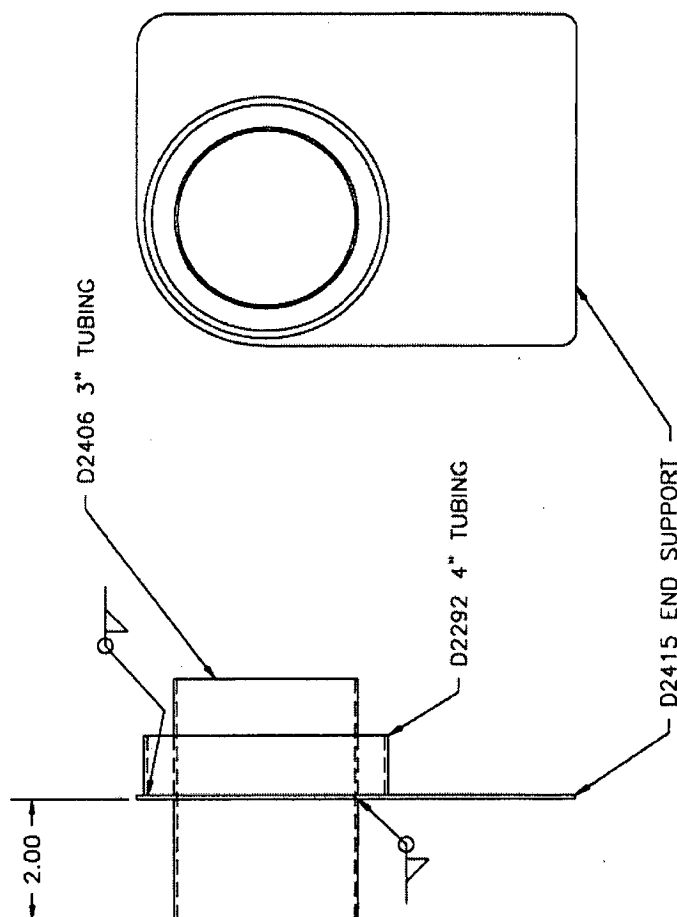
QTY	Part No.	Description
X	D2414	OUTLET WELDMENT ASSEMBLY
1	D2292	4" TUBING
1	D2406	3" TUBING
1	D2415	END PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26906



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2414	REV. A SHEET 2 OF 2
DATE Apr. 6, 1995		TITLE 206 OUTLET WELDMENT	SCALE

RELEASED
96/09/10 BW



FINISH: ANODIZE

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 26906

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

48039

02-Jun-2006

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

PURCHASE ORDER/

NO. DE COMMANDE: 00001342

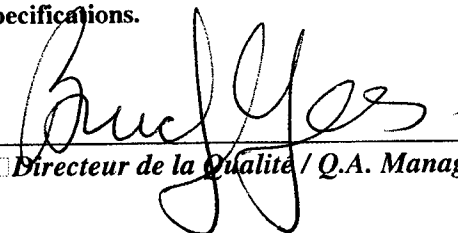


ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	2	2	D2413 B25019 -	RED ANODIZE PER MIL-A-8625F1 TYPE II GLASS 2 ALL OVER
2	3	3	D2414 B26906 -	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER
3	2	2	D2413 & D2414 B24398 -	RED ANODIZE PER MIL-A-8625F1 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: ☐ Directeur de la Qualité / Q.A. Manager ☐